DESIGNATION OF DETAIL SURFACE COATINGS ON DRAWINGS

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ABSTRACT

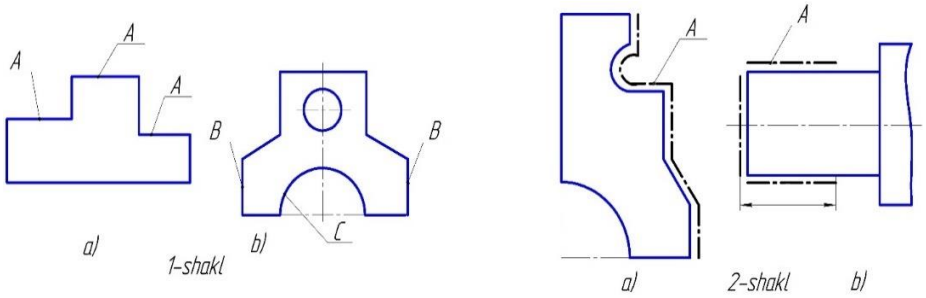
There is no information on the accuracy of the procedures for applying the same coatings and markings to several surfaces of the detail. Currently, solutions to such problems have been found in machine-building enterprises and solutions for their application to technological processes have been presented. Solutions for setting the indicators of material properties in the drawings are provided.

Keywords: Detail, coating, Lok-paint coating, elasticity.

Abbreviations: RC- material hardness according to Rakvel, HB- material hardness according to Brinell, indicators of properties of HRC material obtained by thermal and other types of processing are in the drawings.

Placing coatings on detail surfaces.

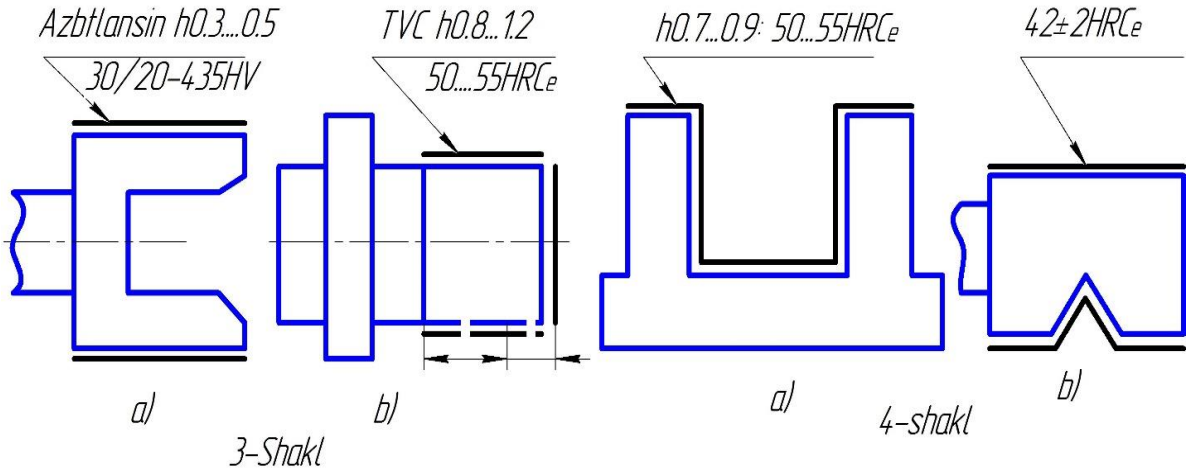
Increasing durability of detailing, protection against corrosion, moisture, In order to protect against the effects of acids, alkalis, etc., coatings are applied to the surfaces of the pipes. If it is necessary to perform the same coating on several surfaces of the part, these surfaces are marked with the same letter (Fig. 1, a), if these surfaces are each requires a different coating, then these surfaces are marked with different letters (Fig. 1, b) and are written in the technical requirements with appropriate notes. Figure 2, b) in case of overlap, the contour of these surfaces is drawn with an extra thick dash-dotted line and is designated by one letter. The length of the part of the detail to be covered is displayed.



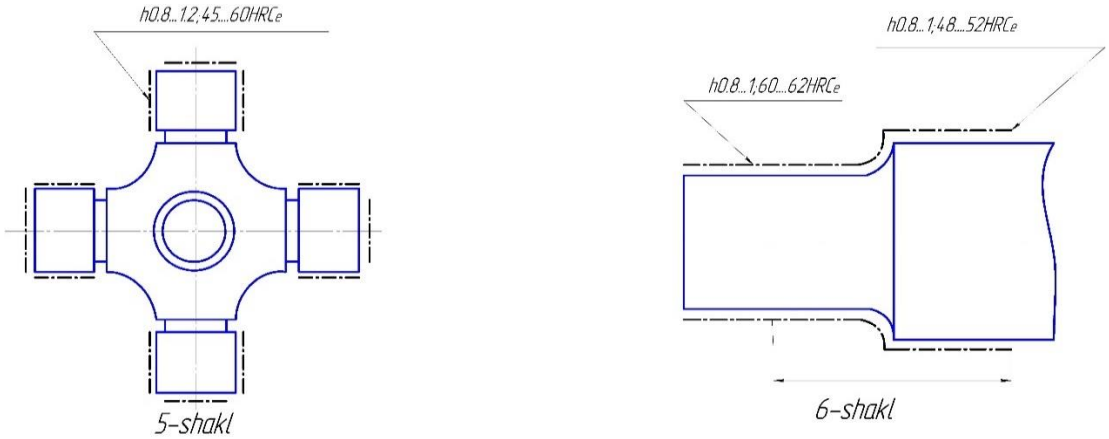
Putting indicators of material properties on drawings.

In cases where details are subjected to thermal or other processing, it is necessary to show the parameters of the properties of materials obtained as a result of processing, i.e. hardness, strength and elasticity limits, depth of processing and other parameters in

the drawings. In the drawings, the hardness of the material is determined by HRC, HRB, HRA, HB, HV and other units, and the processing depth is determined by h. Depth of material processing and hardness values are given as delimited in the drawings.



For example, h 0.8±0.1; HRC±5. The indicators of the properties of the material obtained by thermal and other types of processing are as follows in the drawings: h 0.6...0.9; If 42...46 HRS is written, it means that the thickness (depth) of the workpiece is from 0.6 to 0.9 mm, and its hardness is from 42 to 46 NRS. In the drawings, the processing names are written with words or with conventional abbreviations (Fig. 3, a, b). If the dimensions of the surfaces to be processed can be clearly determined on the drawing, it is not necessary to indicate the dimensions of the connection (Fig. 4, a, b).



If symmetrical parts or surfaces of the detail are treated in the same manner, indicators of material properties are shown once (Fig. 5). Indicators of material properties on parts of detail surfaces if different colors are required, they are separate for each in the drawing is shown (Figure 6). The method of forming a coating is written with an initial letter in the coating symbol: chemical method - khim \ diffusion method - dif, contact method -count; plating because the electrolytic method is the most common method is not shown in the icon.

The coating material is one of the name of the metal or designated by two letters: aluminum - A(Al), iron - T(Fe), tungsten -V(W), bismuth - Vi, gold - Ti(Au), cadmium - K(Cd), manganese - Mn and etc. Coating materials are also determined by alloys: aluminum and zinc - A-R(Al-Zn), iron, copper and cadmium - T-M-K(Fe-Cu-Cd). It is shown that the mass of the component in the alloy is greater. M5(60) indicates that copper-zinc alloy contains 60% copper means In the case of MJR(CuSnHb) (59;28), the inscription is a copper-brass-zinc alloy indicates that it contains 58% copper and 28% brass. Cover ExQ.20 entry electrolytic chrome hard coating thickness reads 20 st. Coating M\8.2Ni\5J. Yal. - electrolytic chrome plating thickness equal to or less than 1 μm, glassy luster, copper layer 18 μm, two layers of nickel read 15 μm thick.

Designation of lacquer coatings. Paint coatings are applied to protect the metal product from deterioration, rusting and improve its appearance. According to the standard requirement, it is determined in the following order:

a) the name, color, technical conditions mark of the paint to be covered;

b) coating series;

d) conditions of use of the coating.

Coatings according to the conditions of use: weather resistant coatings are divided into special environment-resistant coatings. Weatherproof coatings are the capital letter of the alphabet is determined by Light -Y, medium -O‘ (O‘p 0’2, 0’3), hard - Q(Qr Q Q3), very hard JQ (JQp JQJQ}). Coatings resistant to special environments are designated by numbers.

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